

Work Order ID 71738

Monday, July 11, 2011 11:11:13 AM



Page 1

Item ID:	D4278-045	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly, Fwd Cham					
Start Date:	7/11/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	7/21/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	7/10/11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D4277	D	
D4278	C	

100	Weld per dwg A/R S.S. rod Batch: 117884	0.00	Gpc 11.07.14	(2x)
Large Fab	Memo	0.00		
Large Fab	1- Assemble ribs and weld as per dwg DT			

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00	11.07.15	(2)
QC	Memo	0.00		
Quality Control				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 71738




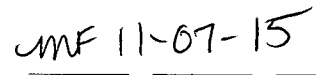

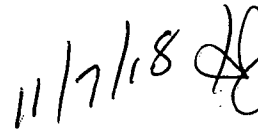
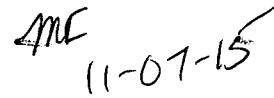
Monday, July 11, 2011 11:11:13 AM



Page 2

Item ID: D4278-045 Accept  Setup Start 
Revision ID:
Item Name: Rib Assembly, Fwd Cham Stop 
Start Date: 7/11/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 7/21/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA-</u> Memo ***STOCK IN BASKET CELL***	0.00 0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 

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NOTE: Date & initial all entries

Picklist Print

Monday, July 11, 2011 11:11:20 AM

Page 1

Work Order ID: 71738

Parent Item: D4278-045

Parent Item Name: Rib Assembly, Fwd Cham

Start Date: 7/11/2011





Required Date: 7/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D4277-11 		Manufactured	No			100	Each	0.0000	1	2			
Rib									 B71737	→	②	11.07.14	
* D4277-7 		Manufactured	No			100	Each	0.0000	1	2			
Rib									 B71758	→	②	11.07.14	

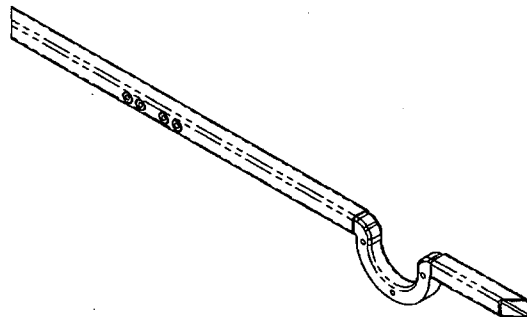
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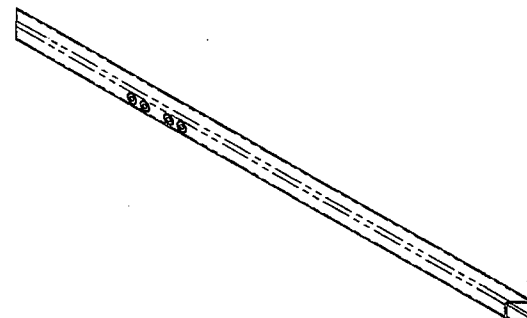
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D4278-041 UPPER RIB ASSY-HOOP



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRAIGHT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71738

PH 0211

RELEASED
2011-01-18
AM

C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV-043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4278	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
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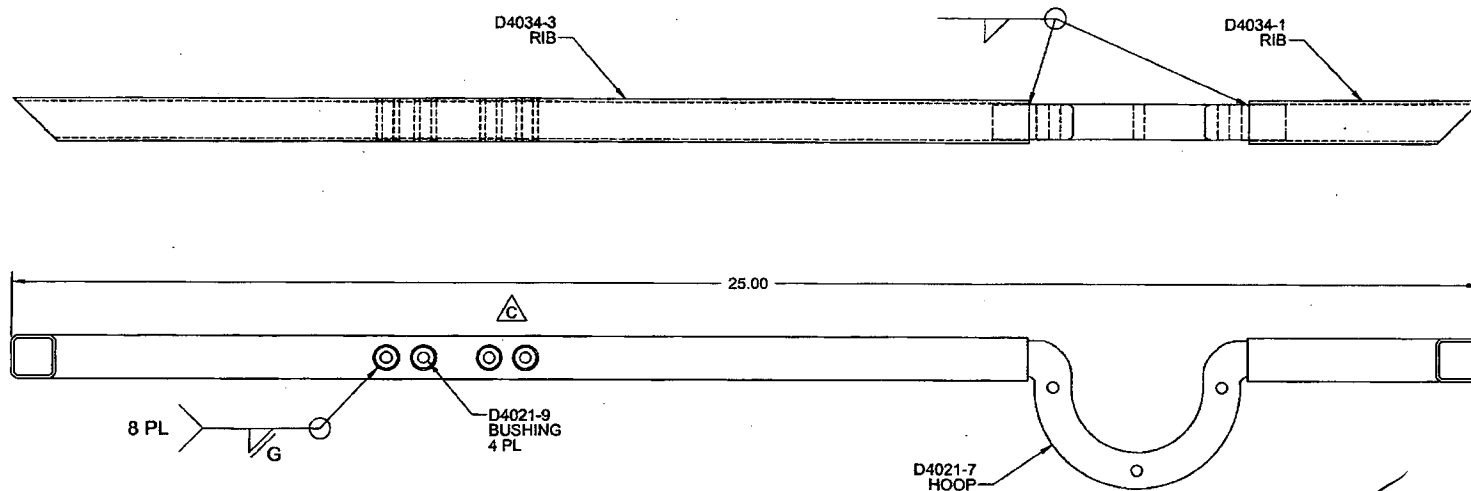
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NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



D4278-041 UPPER RIB ASSY-HOOP

71735

RELEASED
R 2011-01-18
ND

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.61 lbs
 8) WELD PER DART QSI 004

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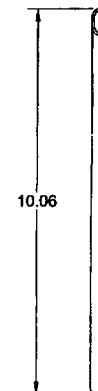
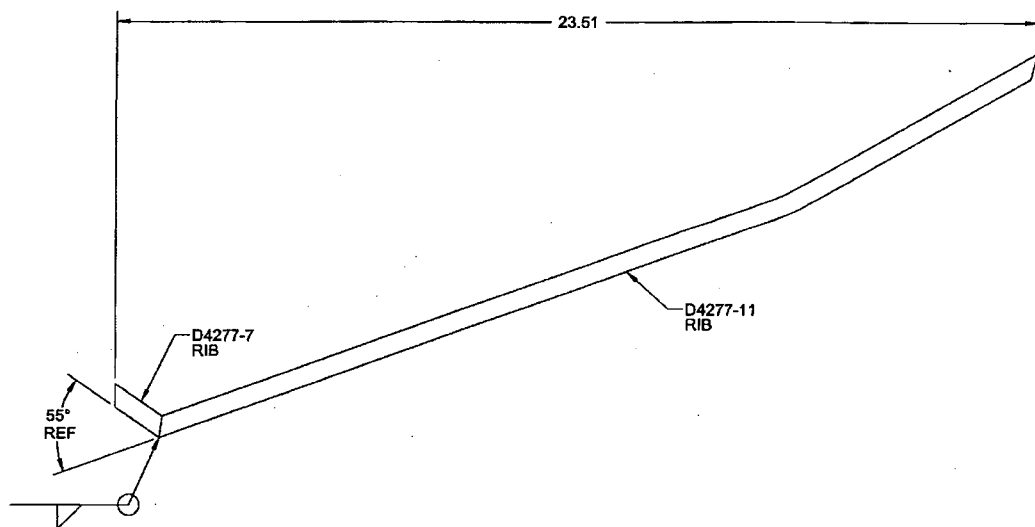
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NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



D4278-045 RIB ASSY, FWD CHAM

M1738

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

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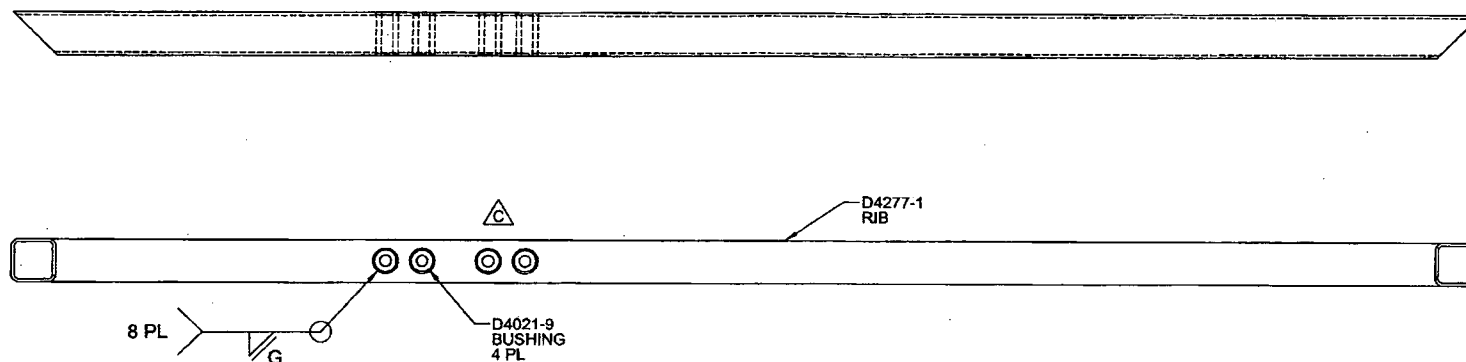
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NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

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2011-01-18

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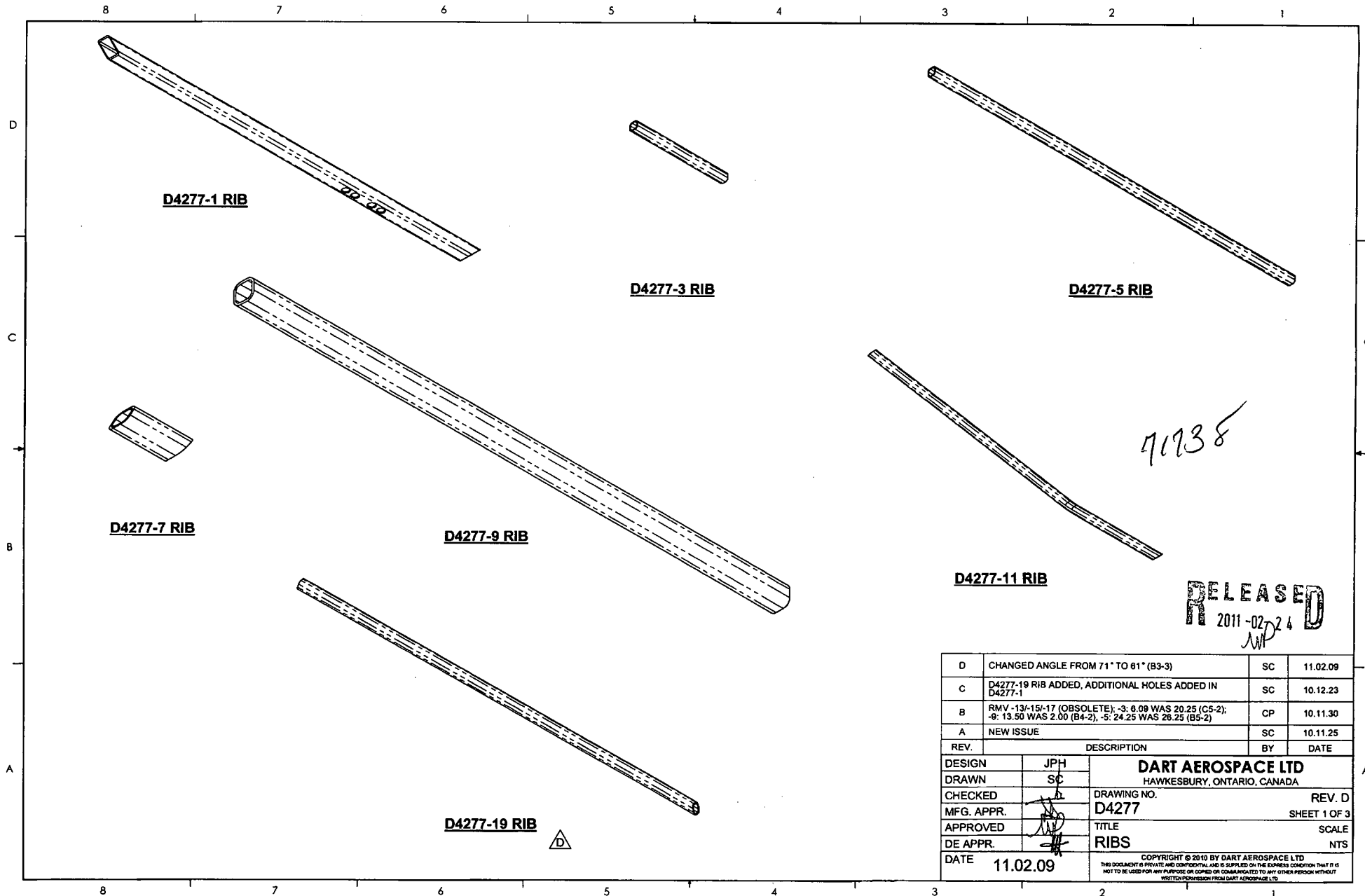
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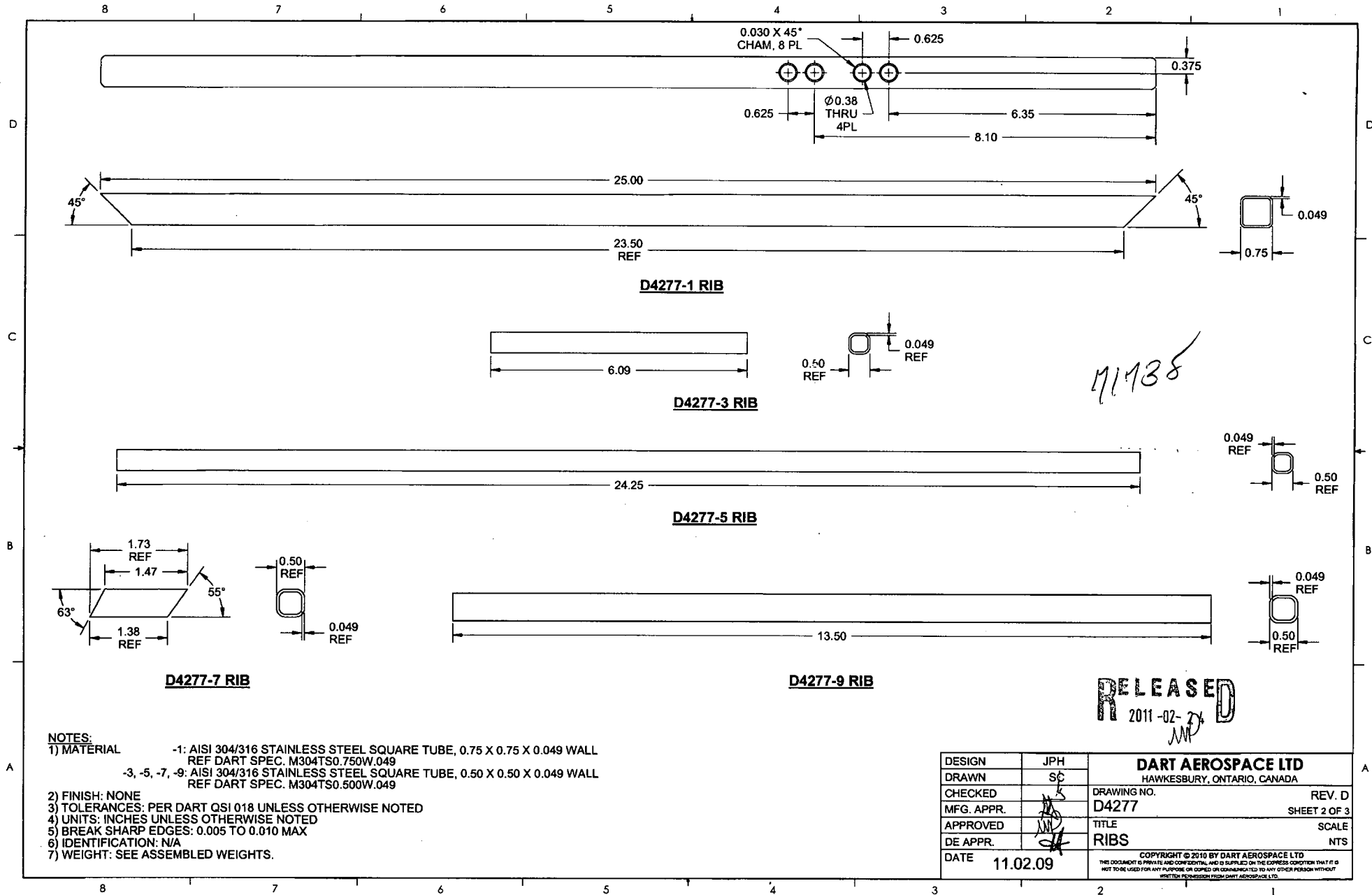
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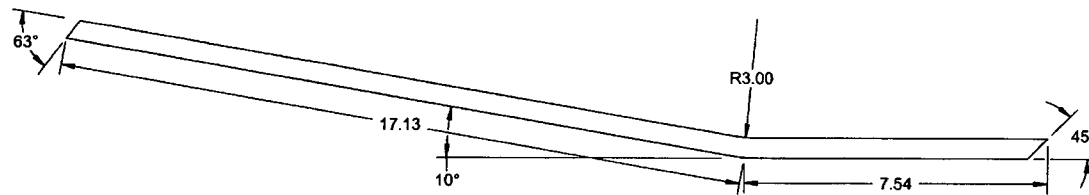
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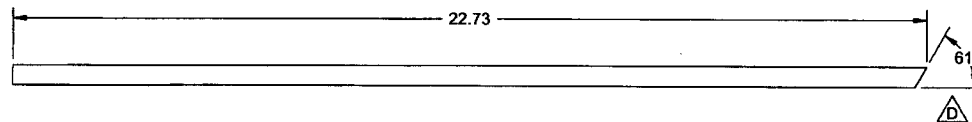
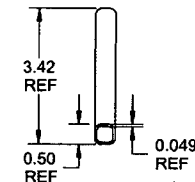
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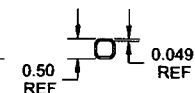
NOTE: Date & initial all entries



D4277-11 RIB



D4277-19 RIB



71738

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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